

Work Order ID 60313

Thursday, July 01, 2010 1:13:06 PM



Page 1

Item ID: D3065-7

Accept



Setup Start



Revision ID:

Item Name: Step Spacer

Stop



Start Date: 7/1/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 7/8/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: H

Date: 10-7-01

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3065

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3065

☐ Dwg Rev: B

☐ Prog Rev: B

☐ 2-

Deburr if necessary

810-8-3

2024 . 046

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

810-8-3

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

810603104

count
+40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 7/1/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 7/8/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Deburr if necessary

12/1/05

140



Brake NC

NC BRAKE

0.00

Memo

0.00

Bend as per Dwg D3065

Sn 10/08/05

150



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

*8/10/05**Count*
446

W/O:		WORK ORDER CHANGES					
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Thursday, July 01, 2010 1:13:06 PM



Page 3

Item ID: D3065-7

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Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 7/1/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 7/8/2010 Req'd Qty: 40.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00				<i>ml</i>	<i>10</i>	<i>08</i>	<i>05</i> (40)
Hand Finishing	Memo	0.00							
170 QC	QC3- Inspect Part Finish	0.00				<i>40</i>	<i>0</i>		
Quality Control	Memo	0.00	<i>M</i>	<i>10/08/09</i>					
180 Packaging	Identify as per dwg & Stock Location: <i>WAB</i>	0.00				<i>10/8/9 SP</i>		(400)	
Packaging	Memo	0.00							

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Thursday, July 01, 2010 1:13:06 PM



Page 4

Item ID: D3065-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 7/1/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 7/8/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/09

NF
10-8-9

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, July 01, 2010 1:13:11 PM

Page 1

Work Order ID: 60313

Parent Item: D3065-7

Parent Item Name: Step Spacer

Start Date: 7/1/2010

Required Date: 7/8/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: ☐C☐02.11.01☐Incorporated D3066-1 IPP☐KJ/RF
IPP Rev:D Now on Water Jet 06-04-11 JLM☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	407.4400	0.1574	6.627368			



2024-T3 .040 sheet



110-8-3

Location

Loc Qty

Loc Code

MAT

96

114415

96

MAT22

311.44

110305

80.33

111786

13.76

112291

28.25

112331

52

113162

137.1

110305

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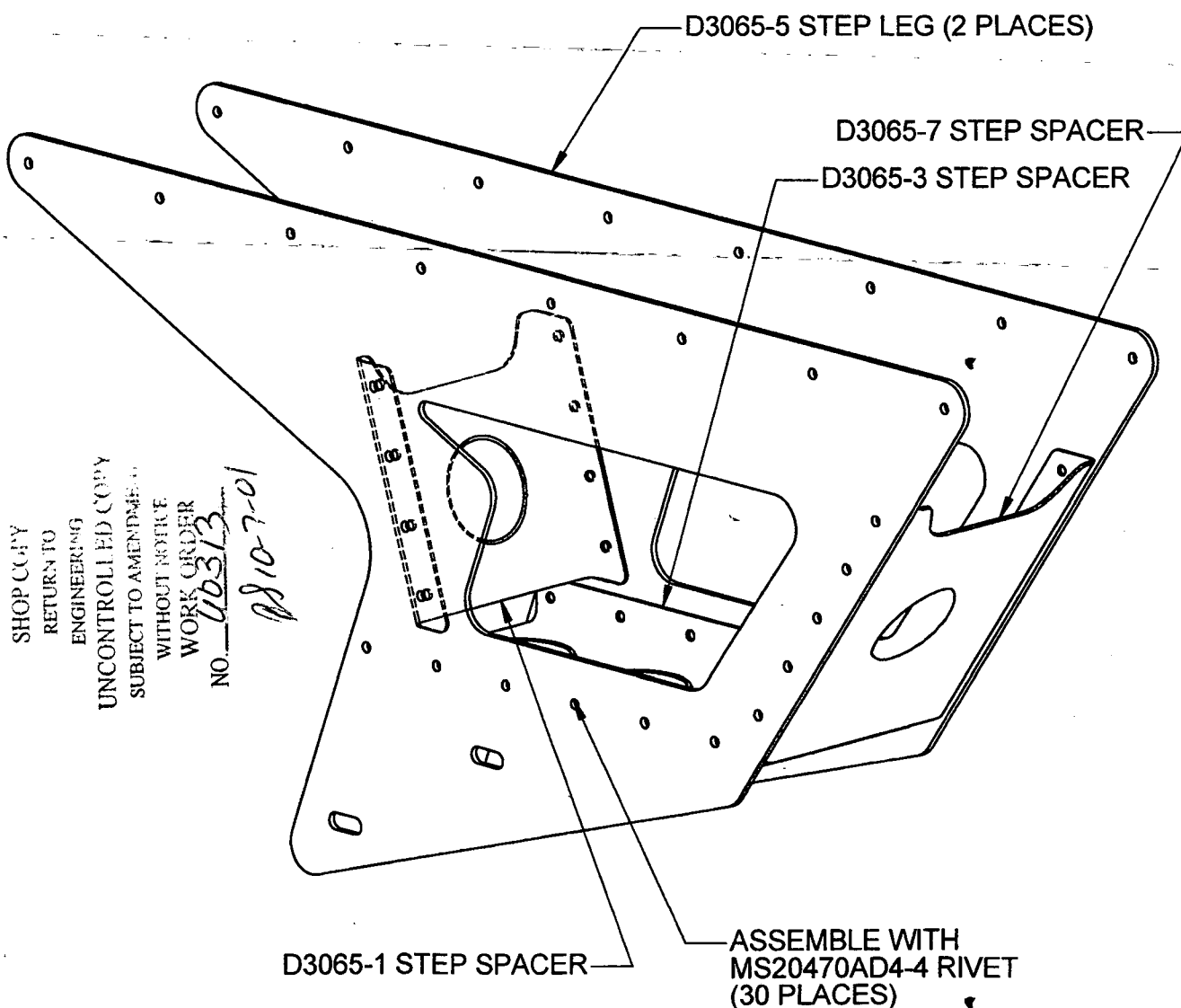
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



D3065-041 STEP LEG ASSEMBLY

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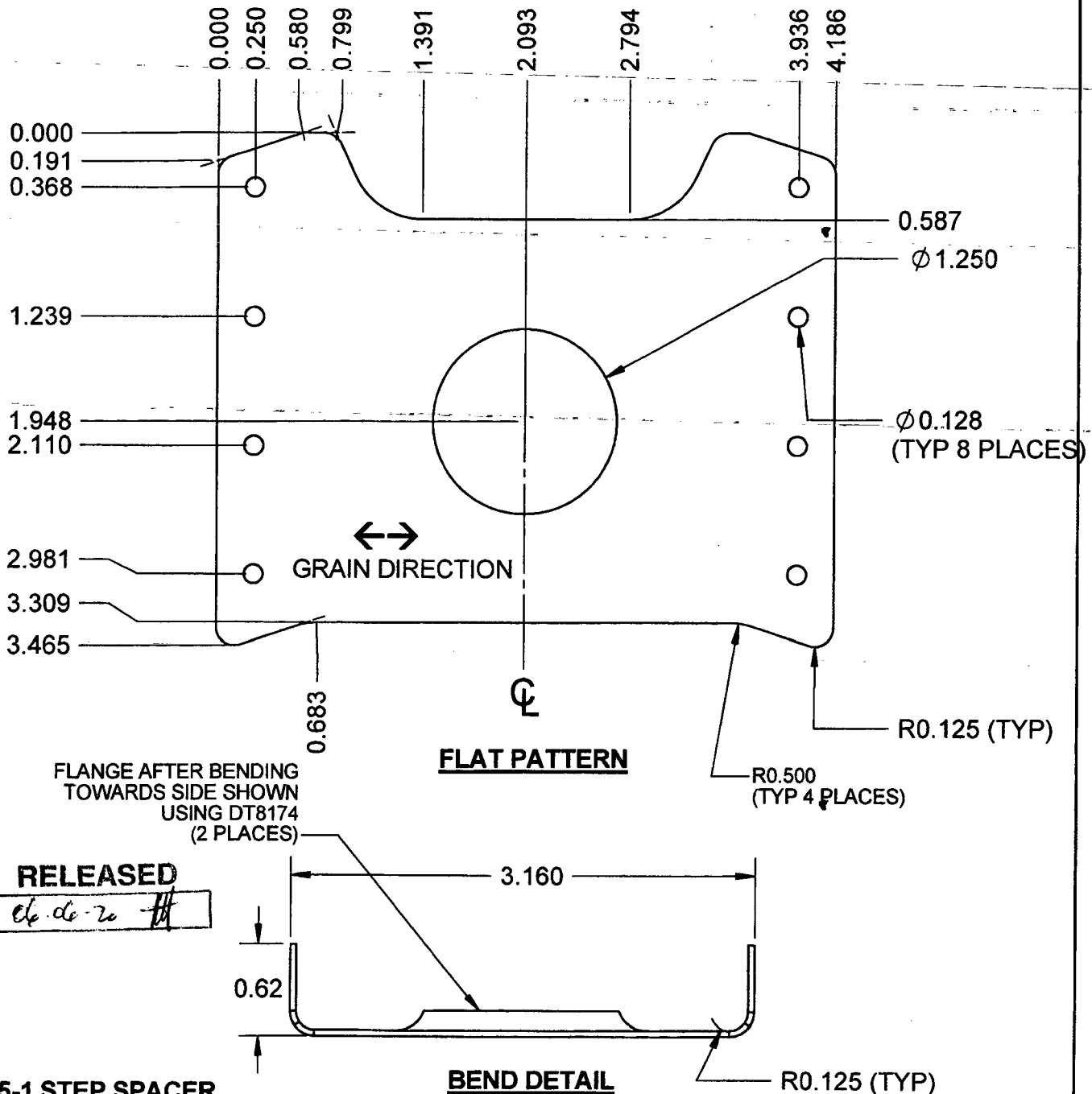
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NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

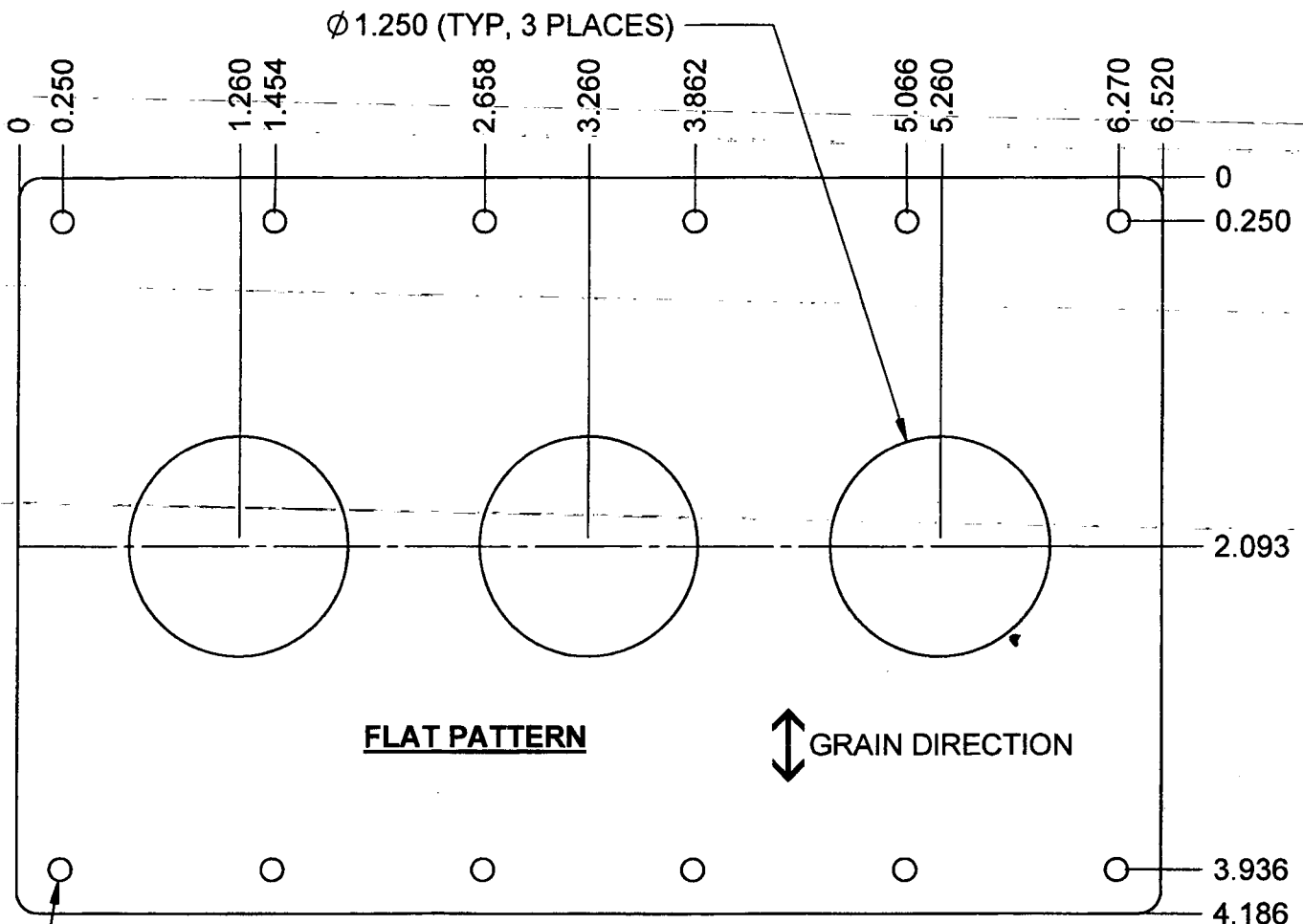
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DART

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

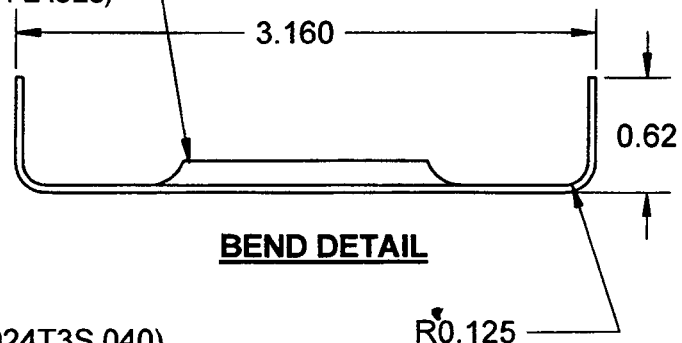


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

06 ch 20



D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd

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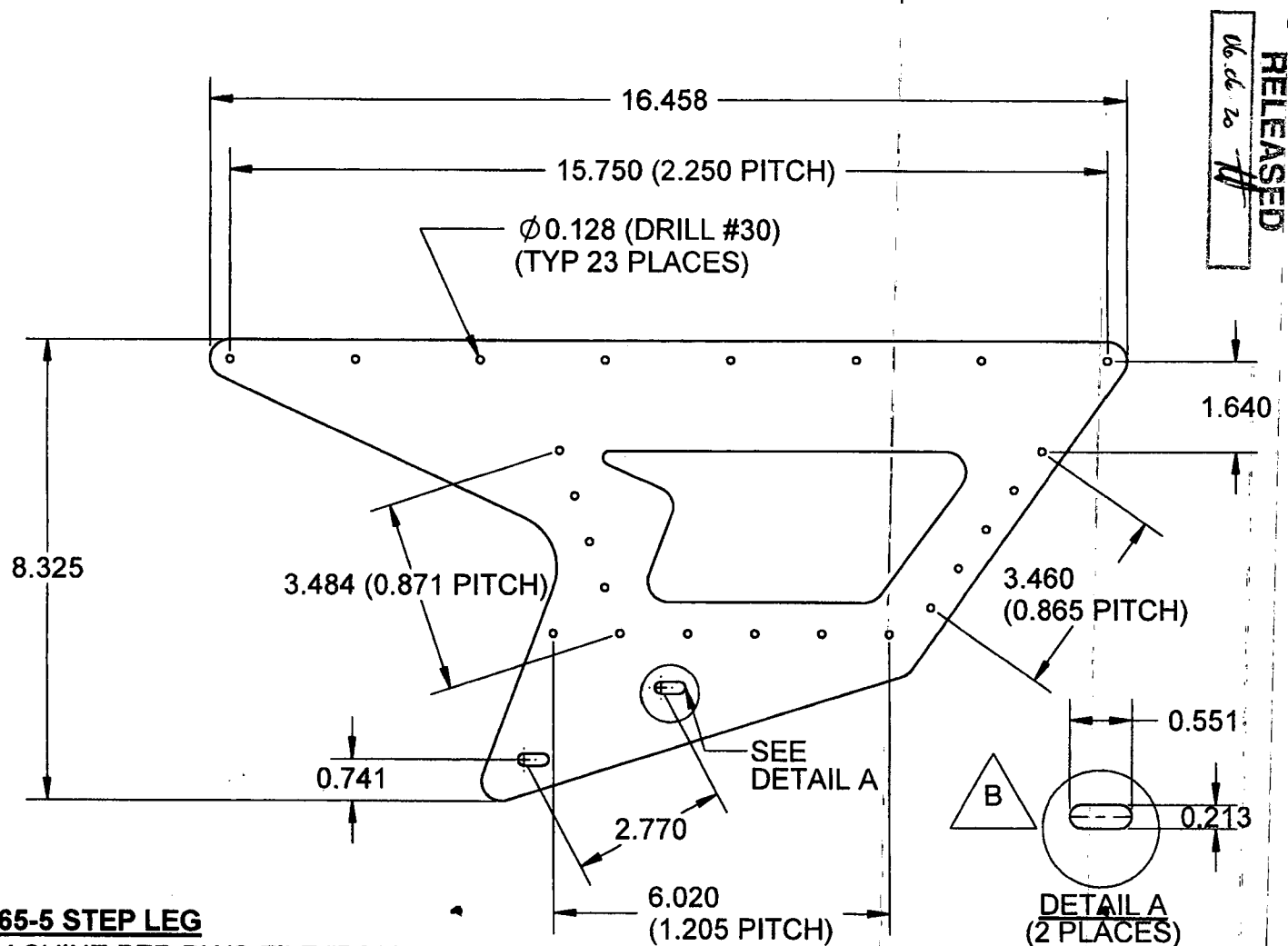
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED CB	DRAWING NO. D3065	REV. B
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SHEET 4 OF 5	
	SCALE 1:3		

**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRJT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

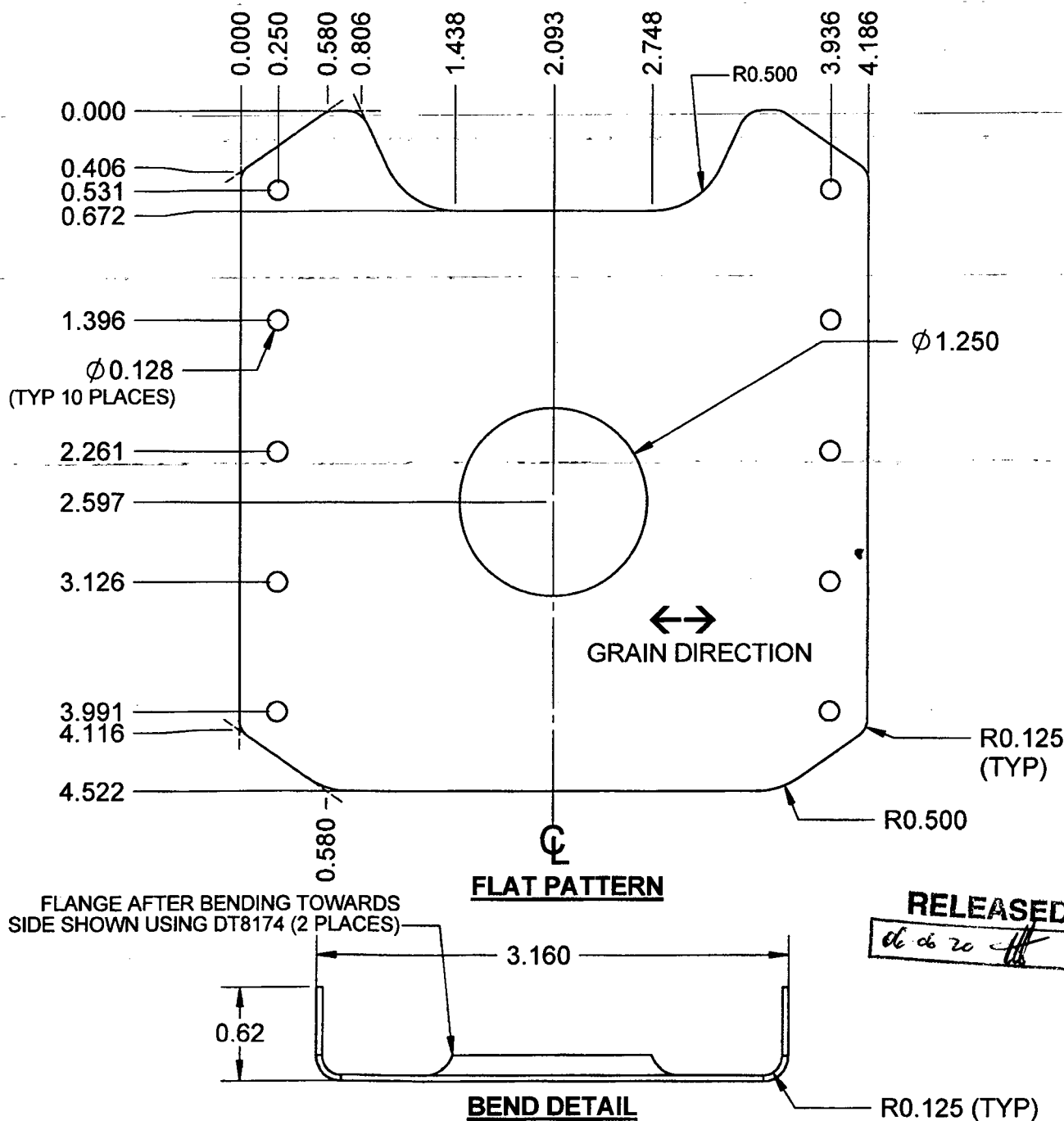
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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